

Work Order ID 77041

\*77041\*

Page 1

November-25-11 8:27:57 AM

Item ID: D3502-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Support

Start Date: 25/11/2011 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 11/11/25 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3502

Rev B

100

0.00

\*100\*

Bandsaw

BAND SAW

Memo

0.00

Jeaspa Bandsaw

Cut blank 3.475 " long! BLANK MAKES 2 PARTS

cut 12/05/22

60

110

0.00

\*110\*

HAAS I

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA649 Rev: AA & Dwg D3502 Rev: B 2-Deburr  
per dwg D3502

cut 12/05/26

60

120

0.00

\*120\*

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

cut 12/05/26

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 77041

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Page 2

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Stop **\*NS2\***

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Start Date: 25/11/2011 Start Qty: 20.00

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Required Date: 09/12/2011 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

SL 12-05-28

**\*130\***

QC

Memo

0.00

Quality Control

140

Small Fab

0.00

**\*140\***

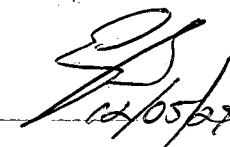
Small Fab

Memo

0.00

Small Fab

Mark hole position using DT9430Drill as per Dwg D3502.

60x 

150

Chemical Conversion Coat per QS1005 4.1

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

60x 

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# Work Order ID 77041

\*77041\*

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November-25-11 8:27:57 AM

Item ID: D3502-1 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Support  
 Start Date: 25/11/2011 Start Qty: 20.00 \*20\* Cust Item ID:  
 Required Date: 09/12/2011 Req'd Qty: 20.00 \*20\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 9:45 FINISH TIME: 10:15 OVEN TEMPERATURE:	0.00 0.00				60 X 0			MA 12/05/31
170 *170* QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				60			PH/253
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: LG 50  Memo	0.00 0.00				60			12/05/31

M121134

32005

9:45

10:15

LG 50

60

12/05/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 77041****\*77041\***

Page 4

November-25-11 8:27:57 AM

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Required Date: 09/12/2011 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

12/6/4

NMF  
12-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

November-25-11 8:28:01 AM

Page 1

Work Order ID: 77041

\*77041\*

Parent Item: D3502-1

\*D3502-1\*

Parent Item Name: Support

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-07-06 JLM  
IPP Rev:B Add tooling hole 07-03-28  
Esr rev C added DT9430 08.11.03 EC verified by:DD

Component-Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B1.000X04.00

Purchased

No

100

f

52.6018

0.289

6.08421T

~~9.10255~~ 9.10255

\*M6061T6B1 000X04 000\*

\*\*

6061-T6 Bar 1.00 x 4.00

Location

Loc Qty

Loc Code

MAT004

52.6018

→ 114352

116808

→ 118400

→ 119346

→ 119513

17.026

24

9.7888

~~2.303~~ 2.303

1.51725

2.4276

~~2.303~~ 2.303

M120603 X 2.731

M121380 X 1.8207

conf 12/05  
/22

W/O:		WORK ORDER CHANGES					
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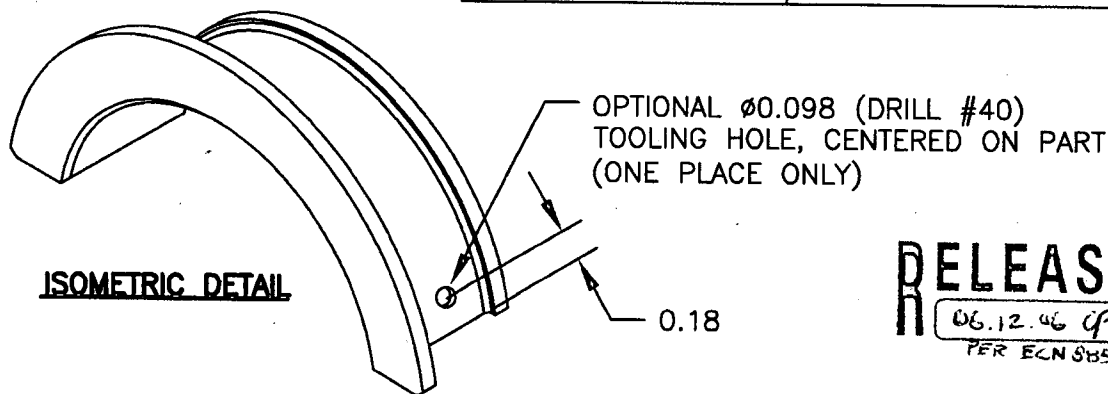
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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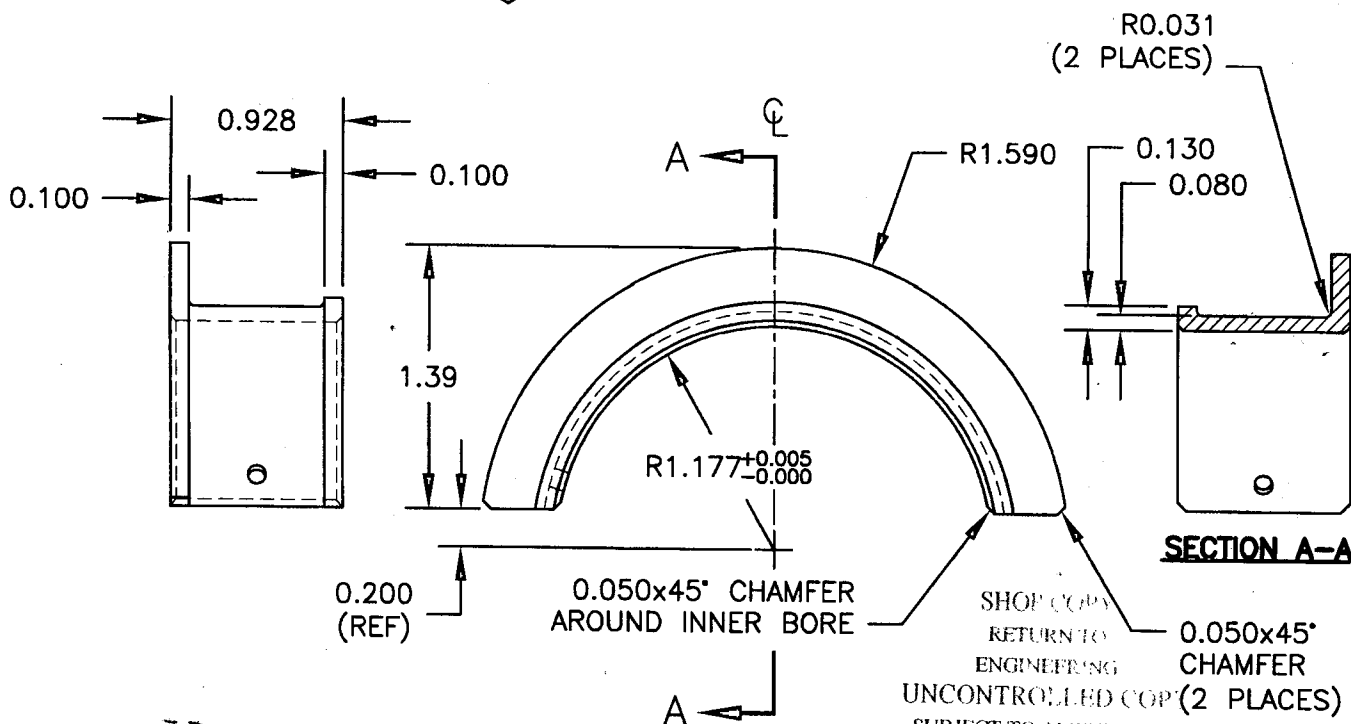
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DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31	TITLE SUPPORT SCALE 1:1		
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	



**RELEASED**  
06.12.06 *qp*  
PER ECN 885



## D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R) NO. 77041 M.C.J.
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ , X.XX =  $\pm 0.030$ ) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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